

**ABSTRACT OF THE DISCLOSURE**

To provide a process for producing a cylinder block with a sleeve in which arc recesses for avoiding interference with the umbrella portions of valves are formed at an intersection between a deck face and a cylinder bore. A sleeve is cast in such a manner that it is embedded in a cylinder block with a space from a deck face simultaneously with the molding of the opening end portion of a cylinder bore and recesses in the cylinder block in the space with a bore pin mated with a sleeve.